

Date: Monday, 09/02/2009 8:26:00 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HEAT OUTLET DEFLECTOR
 Job Number : 45603
 Estimate Number : 12154
 P.O. Number :
 This Issue : 09/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D34721
 Drawing Number : D3472 REV.A
 Project Number : N/A
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : A
 Material :
 Previous Run : 44618 Due Date : 16/02/2009 Qty: 89 Um: Each
 Written By :
 Checked & Approved By :
 Comment : est rev. A 06.02.02 new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.0573 sf(s)/Unit Total : 0.0573 sf(s)
 2024-T3 .040 sheet

Batch: 107572 B 9-2-9

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 Cut as per Dwg D3472
 Dwg Rev: A
 Prog Rev: A

B 9-2-9

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09/02/09 (K9)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

M-H 09/02/09 (KX)

2-Bend as per dwg D3472

3- Buff-out any marks due to bending

SB 09/03/30 9

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Part Number: D34721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8-09/03/30 (X9)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 09/03/31

(9)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-31

(X9)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 101

JS 09/04/01

(X9)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01

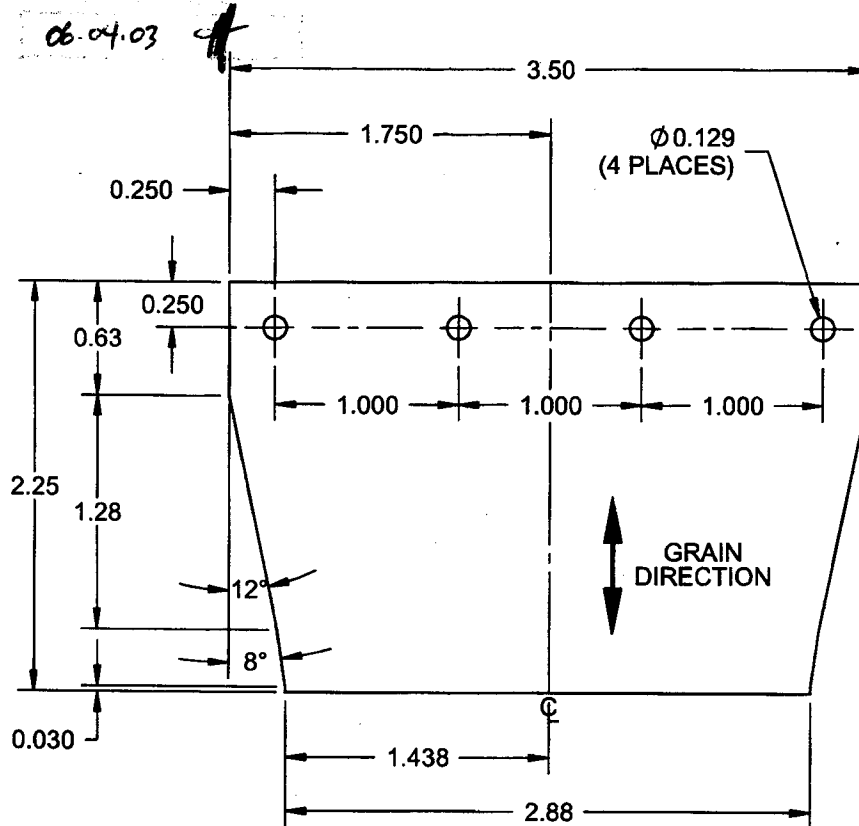
Job Completion



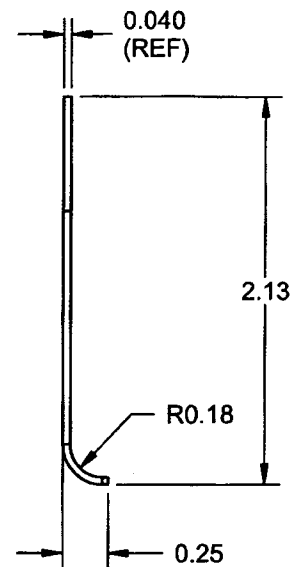
MF 09-04-01



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3472	REV. A SHEET 2 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1



D3472-1F FLAP FLAT PATTERN



D3472-1 FLAP BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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